

Date: Wednesday, 3/12/2008 1:48:28 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, INBOARD, LEFT SIDE
Job Number	: 37866		
Estimate Number	: 10833		
P.O. Number	:	Part Number	: D29331
This Issue	: 3/12/2008 S.O. No. :	Drawing Number	: D2933 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 37367	Material	:
Written By	:	Due Date	: 4/4/2008 Qty: 8 Um: Each
Checked & Approved By	: <u>108 03 12</u>		
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6101001	7075-T7351 2X6X6.25
-----	----------	---------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Issue material from stock: 7075-T7351 QQ-A-250/12
 Cut Size 2.0 x 6.25 X 6.00
 Grain Along Long 6.00 Length
 Batch No: B 34643

8F 08/04/05

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 Program part number and batch number.
 1-Inspect part number and batch number are programmed correctly.
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 5-Deburr

8F 08/04/05

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet

8F 08/04/05

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



Comment: INSPECT ALL DIM TO DIM SHEET

8F 08/04/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/12/2008 1:48:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 37866

Part Number: D29331

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

FW 02.04.07 (8)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 08/04/07 (8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 107550

BR 08-04-07

(8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-L

08/04/07

(8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: *428A*

8/4/07

SD

(8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/08

Job Completion



mr

08-04-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 37866
Description: 206 Saddle, Inboard, Left side		Part Number: D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.130	.127	.133	.133	.133
B	0.100	0.140		.129	.130	.133	.133	.134
C	0.100	0.140		.130	.128	.125	.125	.127
D	0.210	0.230		.221	.217	.220	.221	.222
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.510	.500	.512	.511	.511
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.258	.258	.258	.258	.258
L	0.312	0.317		.315	.316	.316	.316	.316
M	0.235	0.240		.237	.237	.237	.237	.237
N	0.100	0.140		.118	.117	.117	.118	.120
O	0.540	0.560		.545	.550	.550	.553	.551
P	0.490	0.510		.496	.501	.500	.501	.502
Q	3.715	3.725		3.719	3.718	3.719	3.718	3.718
R	2.470	2.510		2.501	2.500	2.500	2.500	2.500
S	0.240	0.270		.252	.253	.254	.252	.249
T	0.100	0.180		.140	.145	.140	.140	.140
U	1.625	1.635		1.633	1.633	1.633	1.633	1.633
V	1.362	1.372		1.370	1.370	1.370	1.370	1.370
W	0.316	0.321		.321	.321	.321	.321	.321
X	1.125	1.145		1.135	1.135	1.136	1.135	1.135
Y	1.565	1.585		1.575	1.575	1.576	1.576	1.570
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
AE								

Accept/Reject

Measured by: RF	Date: 08/03/01
Audited by: [Signature]	Date: 08.01.01
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	

DART AEROSPACE LTD				Work Order: 37866	
Description: 206 Saddle, Inboard, Left side				Part Number: D2933-1	
Inspection Dwg: D2933 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

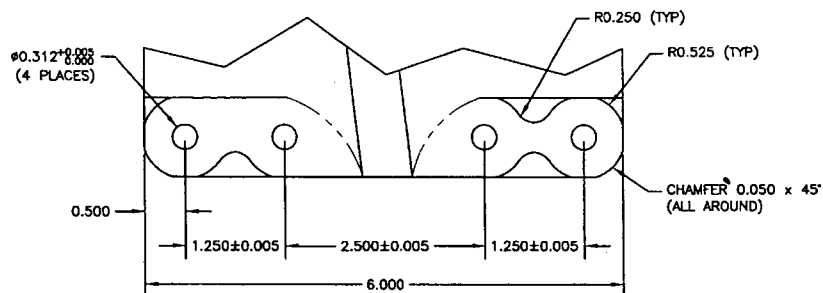
☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.100	0.140		.135	.132	.127		
B	0.100	0.140		.131	.132	.125		
C	0.100	0.140		.130	.130	.130		
D	0.210	0.230		.225	.222	.221		
E	1.245	1.255		1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500		
H	0.510	0.515		.511	.511	.511		
I	1.572	1.582		1.577	1.578	1.570		
J	2.495	2.505		2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258		
L	0.312	0.317		.316	.316	.316		
M	0.235	0.240		.237	.237	.237		
N	0.100	0.140		.120	.120	.121		
O	0.540	0.560		.550	.499	.499		
P	0.490	0.510		.500	.500	.500		
Q	3.715	3.725		3.718	3.718	3.719		
R	2.470	2.510		2.493	2.495	2.494		
S	0.240	0.270		.254	.257	.253		
T	0.100	0.180		.140	.140	.140		
U	1.625	1.635		1.633	1.633	1.633		
V	1.362	1.372		1.370	1.370	1.370		
W	0.316	0.321		.321	.321	.321		
X	1.125	1.145		1.135	1.135	1.137		
Y	1.565	1.585		1.570	1.570	1.572		
Z	0.178	0.198		.188	.188	.188		
AA								
AB								
AC								
AD								
AE								

Accept/Reject

Measured by: <i>St</i>	Date: 08/04/08
Audited by: <i>Clund</i>	Date: 02-04-07
Prototype Approval: N/A	Date: N/A

Rev.	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	<i>DD</i>

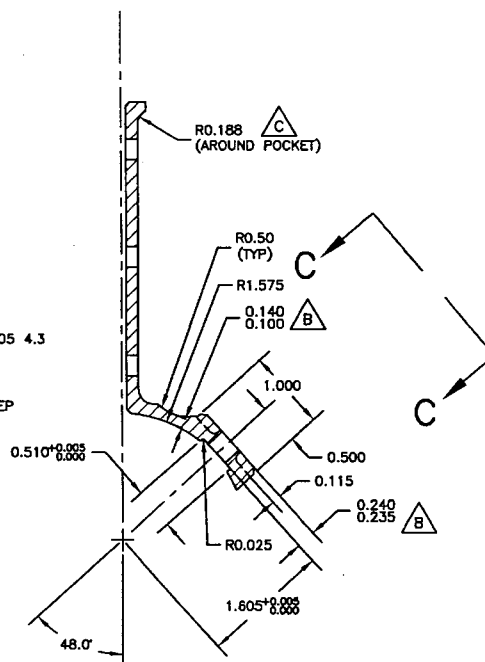


VIEW C-C

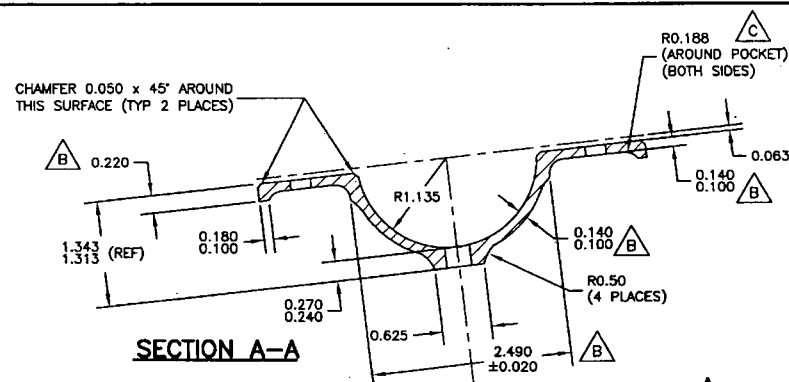
D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

NOTES:

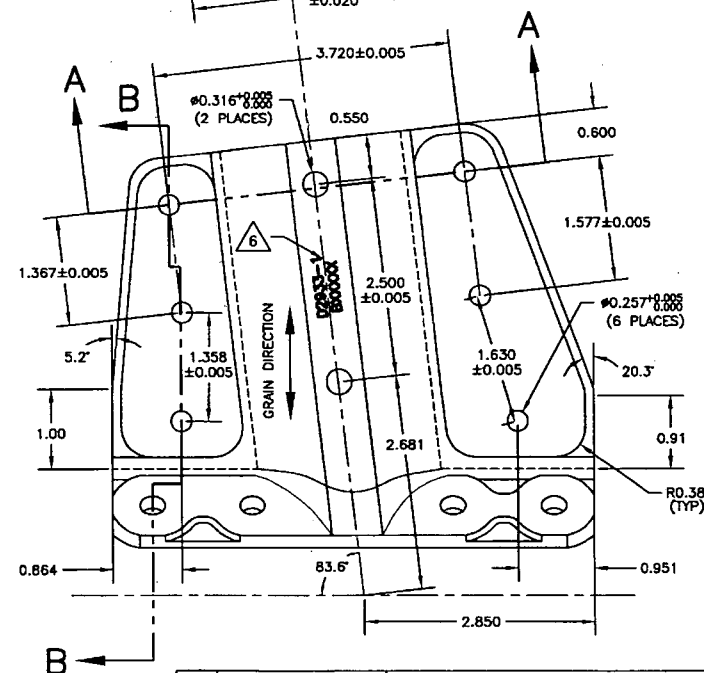
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	DRAWING NO. D2933
		TITLE SADDLE INSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

COPYRIGHT © 1999 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

DART DART AEROSPACE USA, INC.
BELLEVUE, WA

NO. 37860
WORK ORDER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
SHOP COPY
RETURN TO
ENGINEERING
COPY

RELEASED
07.02.12